

Work Order ID 76808***76808***

Page 1

Monday, November 21, 2011 11:30:42 AM

Item ID: D2661-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 11/21/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 12/16/2011 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: *P*Date: *11/24*

Tooling:

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2661

Rev E

100

0.00

100

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

Program part number and batch number.

Program part number and batch number
MACHINE AS PER DWG AND FOLIO FB073FOLIO REV: *AA*DWG REV: *B*

0.00

110

0.00

110

Mill Conv

Conventional Milling Machine

CONVENTIONAL MILLING MACHINE

Memo

Machine Keyway and inspect per attached dimension sheet *FK 11/12/29*

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76808

Monday, November 21, 2011 11:30:42 AM

N900040100

Setup Start *NS1*

Stop *NS2*

8

Cust Item ID:

Start Date: 11/21/2011 **Start Qty:** 8.00

Required Date: 12/16/2011 **Req'd Qty:** 8.00

8

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

QC2- Inspect parts off machine FAI/FAIB

0.00

SL/D.A 11/12/22
F.K. 11/12/29.

120

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

mk 2/01/03

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

8x4 m-l 12/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76808***76808***

Page 3

Monday, November 21, 2011 11:30:42 AM

Item ID: D2661-1 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, LH Fwd Aft Out 206
Start Date: 11/21/2011 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 12/16/2011 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

150

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

0.00

OVEN TEMPERATURE:

8X4 M/L 12/01/05

160	QC3- Inspect Part Finish	0.00							
-----	--------------------------	------	--	--	--	--	--	--	--

160

QC

Quality Control

Memo

0.00

8 BK 12-1-6

170	Identify as per dwg & Stock Location: <u>435</u>	0.00							
-----	--	------	--	--	--	--	--	--	--

170

Packaging

Packaging

Memo

0.00

12/1/6 SF 82

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, November 21, 2011 11:30:47 AM

Page 1

Work Order ID: 76808

76808

Parent Item: D2661-1

D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 11/21/2011

Required Date: 12/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	134.0000	1	8			

D6101-003

Saddle Billet, 7075

**

11-12-28

Location	Loc Qty	Loc Code
MAT040	105	
72226	8	
73775	36	
73780	7	
74650	54	
MAT44	29	
72226	2	
73769	1	
74680	26	

76837

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 74808
Description: 206 Saddle, Outboard, Left side	Part Number: D2661-1
Inspection Dwg: D2661 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.126	0.127	0.127	0.130		
B	0.100	0.140		0.125	0.122	0.122	0.124		
C	1.125	1.145		1.140	1.138	1.1382	1.136		
D	0.615	0.685		0.680	0.680	0.680	0.680		
E	0.240	0.260		0.247	0.247	0.247	0.248		
F	1.313	1.343		1.324	1.322	1.323	1.324		
G	0.210	0.230		0.223	0.219	0.222	0.222		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.581	1.5783	1.5782	1.576		
K	0.235	0.240		.237	.237	.237	.236		
L	0.100	0.120		.110	.110	.110	.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.316	0.316	0.316	0.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.797	0.797	0.797	0.797		
W	0.540	0.560		0.550	0.550	0.550	0.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.922	0.922	0.922	0.922		
AA	0.490	0.510		0.500	0.503	0.501	0.499		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: b.a. / F.K.	Audited by: [Signature]
Date: 11/12/22 / 11/12/29	Date: 12/01/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76808
Description: 206 Saddle, Outboard, Left side		Part Number: D2661-1
Inspection Dwg: D2661 Rev. D		Page 1 of 1

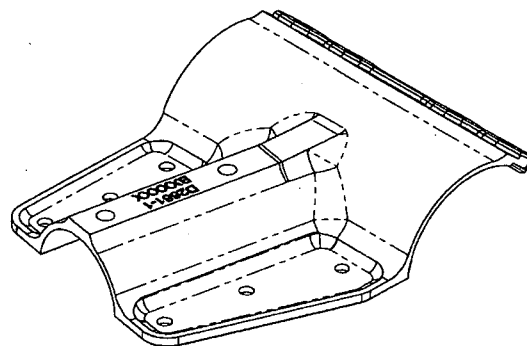
Inspect dimensions highlighted on inspection sheet drawing D2661 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	16	17	18		
A	0.100	0.140		0.131	0.130	0.130	0.130		
B	0.100	0.140		0.124	0.125	0.125	0.125		
C	1.125	1.145		1.136	1.137	1.137	1.137		
D	0.615	0.685		0.680	0.680	0.680	0.680		
E	0.240	0.260		0.251	0.251	0.250	0.250		
F	1.313	1.343		1.324	1.324	1.324	1.324		
G	0.210	0.230		0.222	0.222	0.222	0.222		
H	0.100	0.180		0.135	0.135	0.135	0.135		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.576	1.577	1.577	1.577		
K	0.235	0.240		0.236	0.236	0.237	0.237		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		0.512	0.512	0.512	0.512		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.316	0.316	0.316	0.316		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		0.797	0.797	0.797	0.797		
W	0.540	0.560		0.550	0.550	0.550	0.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		0.260	0.260	0.260	0.260		
Z	0.912	0.932		0.922	0.922	0.922	0.922		
AA	0.490	0.510		0.500	0.500	0.501	0.501		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

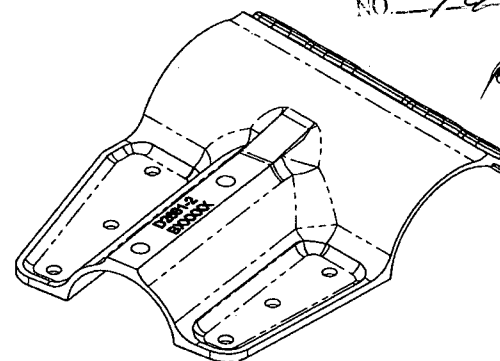
Measured by:	D.A. / FK
Date:	11/12/22 / 11/12/29

Audited by:	CMJ
Date:	12/01/23

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

SHOP COPY
 REFERENCE TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 74808

R11-11-21

RELEASED
 2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4). REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	08.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>Q</i>	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	<i>Q</i>		
CHECKED	<i>ASS</i>		
MFG. APPR.	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.10.31	DRAWING NO.	D2661
		TITLE	SADDLE, OUTSIDE
		SCALE	NTS

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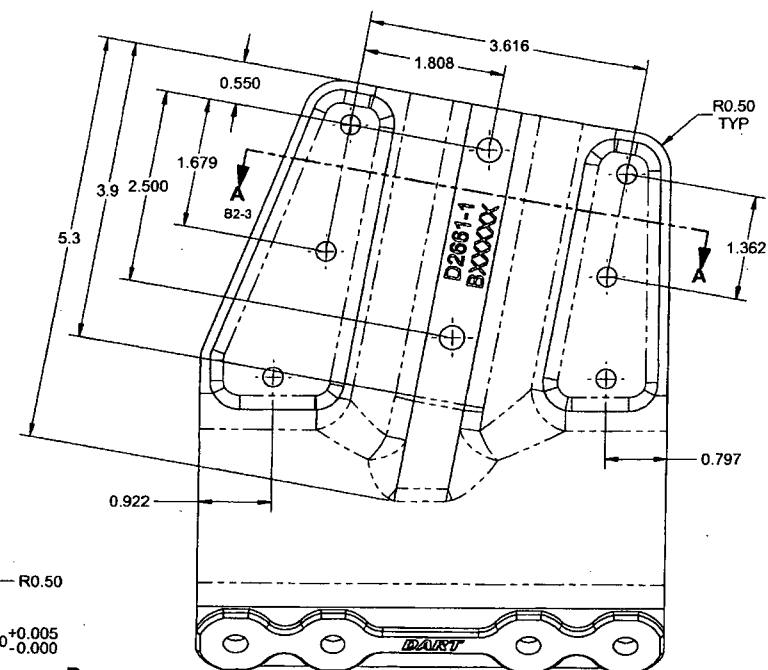
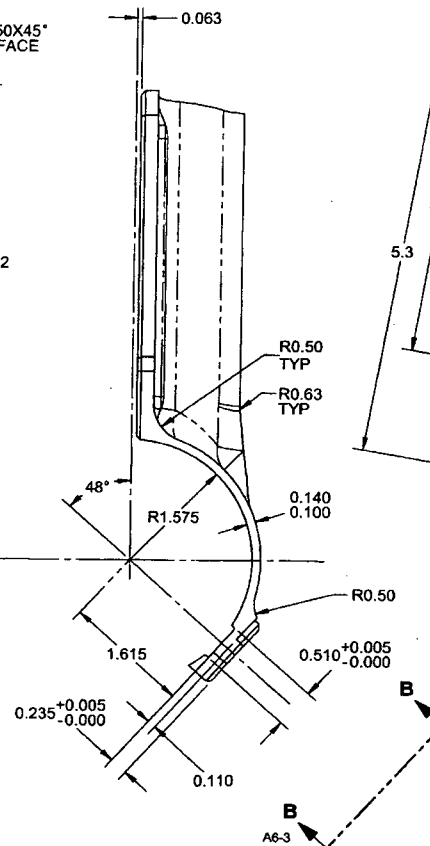
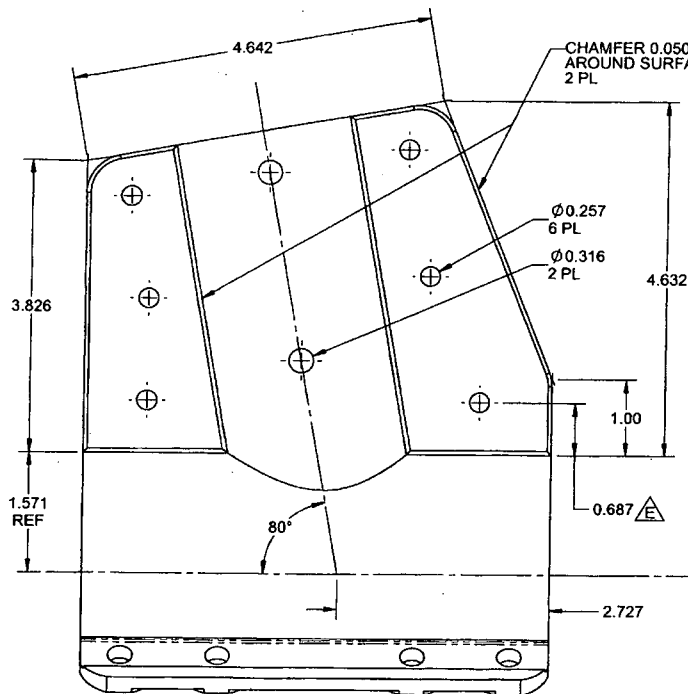
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2661-1 SADDLE, OUTSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	g	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
DATE	11.10.31	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2011-11-16

76808

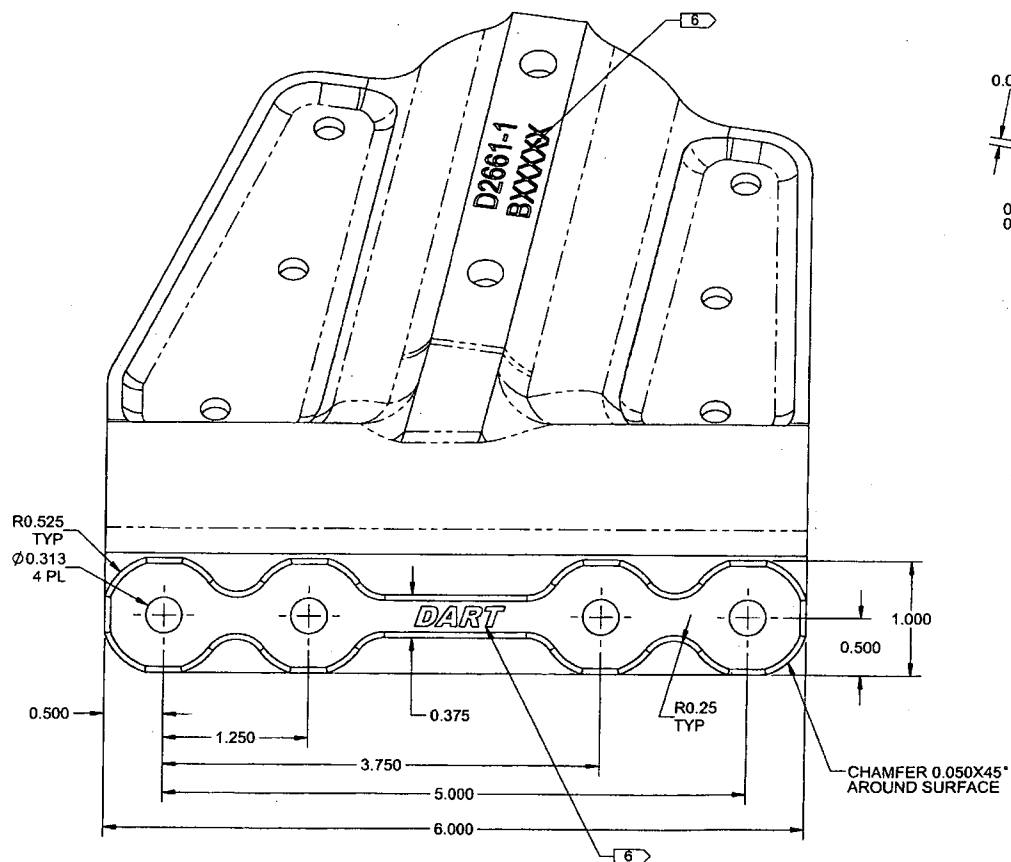
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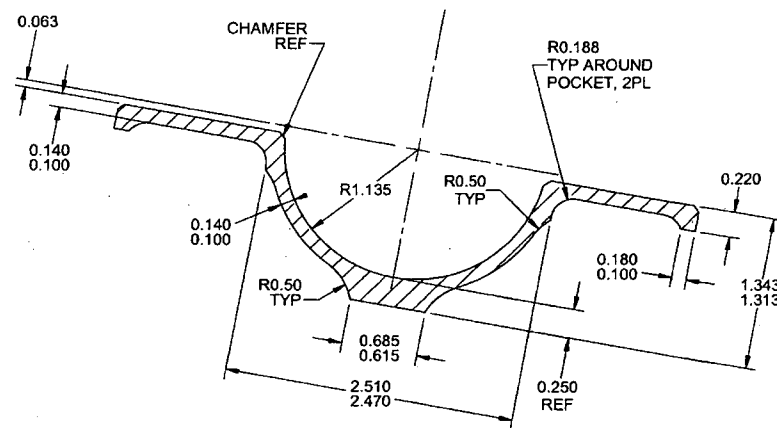
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NOTE: Date & initial all entries



VIEW B-B
SCALE 1.5X
VIEW ROTATED



VIEW A-A
SCALE 1.5X

76808

RELEASED
2011-11-16

DESIGN	g	DART AEROSPACE USA, INC.	
DRAWN	AS	KENT, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 3 OF 5
APPROVED	IND	TITLE	SCALE
DE APPR.	#	SADDLE, OUTSIDE	NTS
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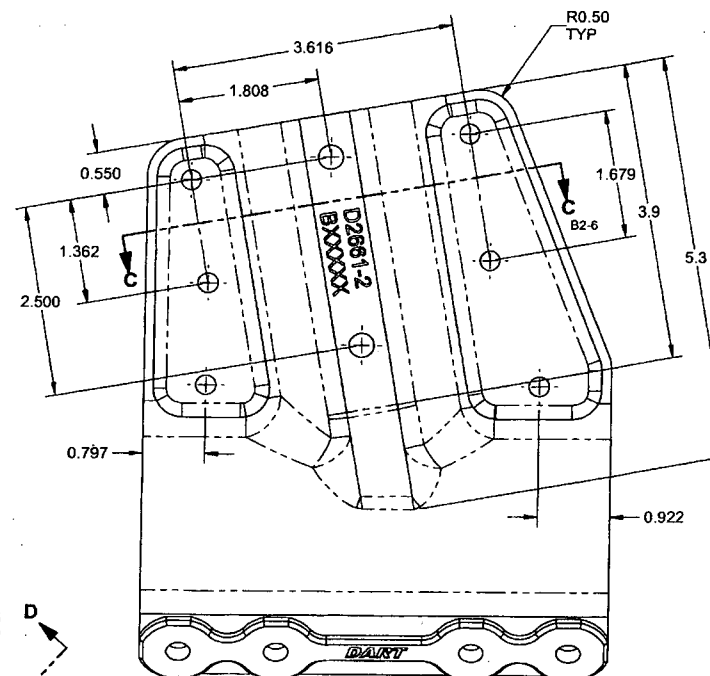
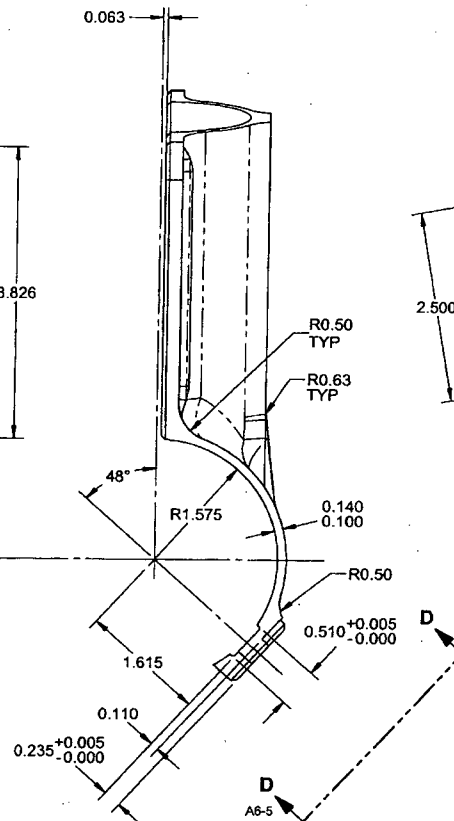
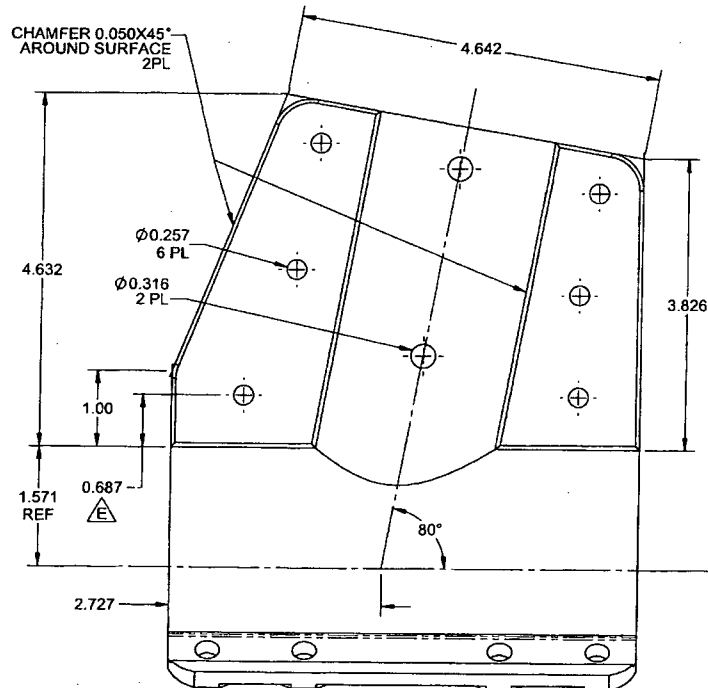
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CHAMFER 0.050X45°
AROUND SURFACE
2PL



D2661-2 SADDLE, OUTSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN	JP	KENT, WA	
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
DATE	11.10.31	<small>COPYRIGHT © 1997 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON OR WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

RELEASED
R 2011-11-16

76808

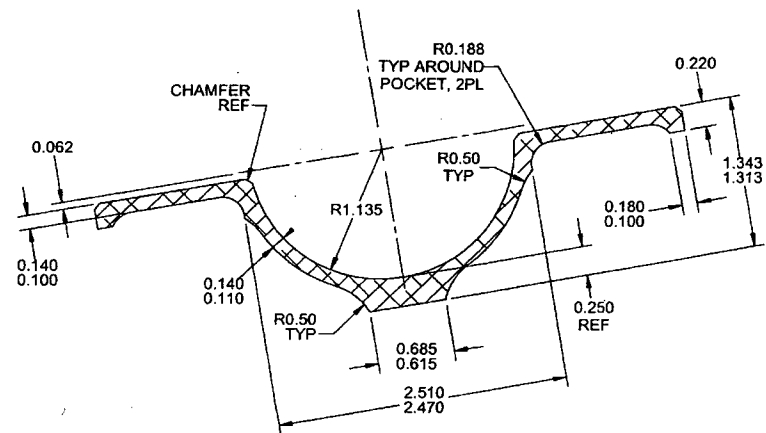
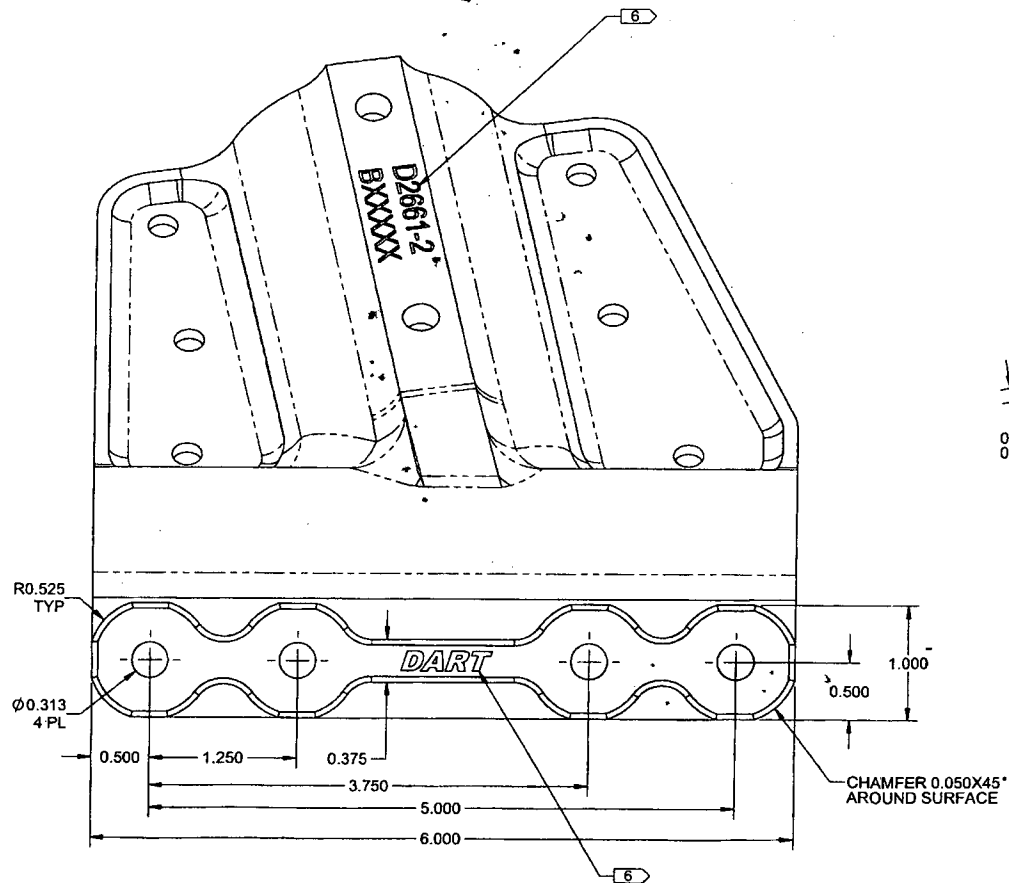
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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